

RCSH

Date: Thursday, 06/11/2008 1:00:52 PM
User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 43234		
Estimate Number	: 12959		
P.O. Number	:	Part Number	: D36421
This Issue	: 06/11/2008 S.O. No. :	Drawing Number	: D3642 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type / : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 36489	Material	:
Written By	:	Due Date	: 13/11/2008 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-07-20 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.1747 sf(s)/Unit Total : 3.4944 sf(s)
2024-T3 .050 sheet
Batch: 107711 IB 8-11-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3642
Dwg Rev: B
Prog Rev: B

IB 8-11-6

2-Deburr if necessary IB 8-11-6



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-11-6

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Solution

counter



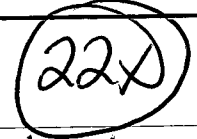
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-1

08/11/10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/11/2008 1:00:52 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 43234

Part Number: D36421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JK



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

OE- 11-11

22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 262

8/11/10

22x

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/12

Job Completion



MF 08-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

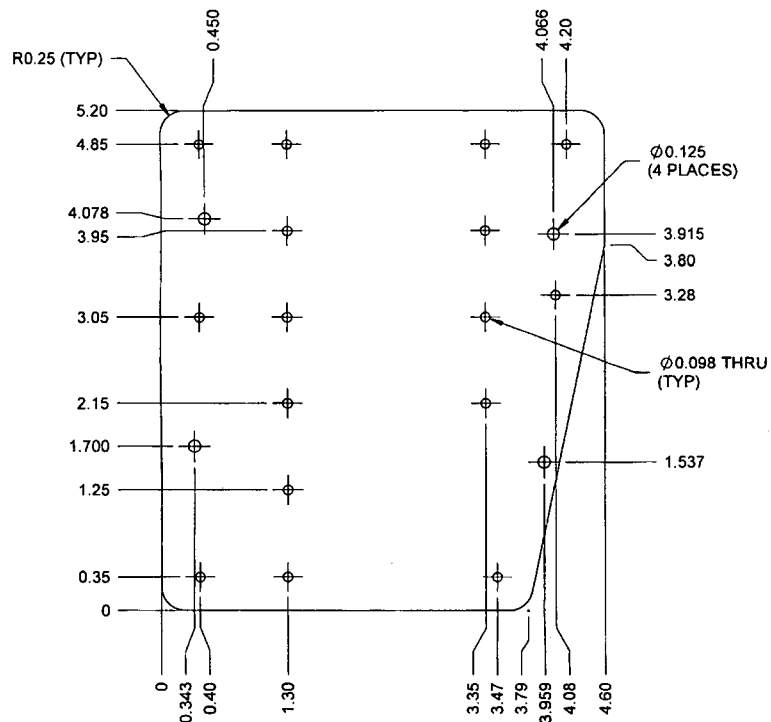
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

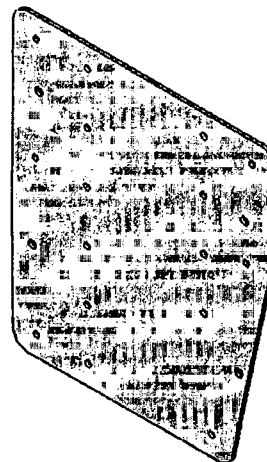
NOTE: Date & initial all entries

W/O: 43234

C20811106



D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2)



RELEASED
07.11.14

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	UC		
CHECKED	RA		
MFG. APPR.	EG		
APPROVED	TH		
DE APPR.			
DATE	07.10.16		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3642	REV. B
TITLE DOUBLER	SCALE 4:5
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DART AEROSPACE LTD		Work Order: 43234
Description: Double		Part Number: D3642-1
Inspection Dwg: D3642-1, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	X			
Ø .125	+ .004 - .001	.128	X			
.35	+/- .030	.351	X			
1.25	+/- .030	1.253	X			
1.700	+/- .010	1.703	X			
2.15	+/- .030	2.156	X			
3.05	+/- .030	3.053	X			
3.95	+/- .030	3.958	X			
4.078	+/- .010	4.078	X			
4.85	+/- .030	4.856	X			
5.20	+/- .030	5.204	X			
1.537	+/- .010	1.539	X			
3.28	+/- .030	3.287	X			
3.915	+/- .010	3.917	X			
.343	+/- .010	.345	X			
.140	+/- .030	.1404	X			
1.36	+/- .030	1.362	X			
3.35	+/- .030	3.354	X			
3.47	+/- .030	3.472	X			
3.959	+/- .010	3.958	X			
4.08	+/- .030	4.079	X			
4.66	+/- .030	4.600	X			
.450	+/- .010	.4498	X			
4.666	+/- .010	4.669	X			

Insured by:	B
Date:	8-11-6

Audited by:	S
Date:	08/11/10

Prototype Approval:	1
Date:	4

Date	Change	Revised by	Approved
	New Issue	KJ/JLM	